

# Work Order ID 69790

Thursday, May 19, 2011 12:30:05 PM



Ship today Page 1

Item ID: D407-802-018

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-05-19*

Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	A								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-018 CHG001

*8/15/19*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*11/5/19*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/15/19*

*(Signature)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69790**

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Item ID: D407-802-018

Accept



Setup Start



Revision ID:

Stop



Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-018								
	Location: _____								
	PPP rev: <u>PPD</u>								
130		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/5/19  
ME  
11-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Page 1

Work Order ID: 69790

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC  
10.12.03 as per dwg rev.A DD verf:EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3552-17  Door Prop		Manufactured	No			105	Each	7.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Location Loc Qty Loc Code

ST272	7	
64338	7	

D3622-5  Ball Stud		Manufactured	No			105	Each	54.0000	1	1			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST070	54	
64330	14	
64428	20	
65087	20	

D4108-3  Door Doubler, Right		Manufactured	No			105	Each	8.0000	1	1			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

st128	8	
62302	4	
64485	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 69790

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4108-5  
Small Right Door Doubler

Manufactured No

105 Each

7.0000



1  
SP

Location

Loc Qty

Loc Code

st128

7

62303

5

64486

2

1

D4108-11  
Template

Manufactured No

105 Each

12.0000



1  
SP

Location

Loc Qty

Loc Code

st128

12

62304

3

64488

9

1

D4108-047  
Sill Doubler Assembly

Manufactured No

105 Each

7.0000



1  
SP

Location

Loc Qty

Loc Code

ST129

7

63015

3

64489

4

1

CR3523-4-02  
RIVET

Purchased No

105 Each

335.0000



19  
11/15/12

Location

Loc Qty

Loc Code

ST312

232

116915

132

117291

100

ST313

103

116391

100

116893

3

19

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 69790

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-4

Purchased

No

105

Each

90.0000

4



Rivet



4 1/4 SP

Location

Loc Qty

Loc Code

ST314

90

115768

90

MS20426AD4-6

Purchased

No

105

Each

1,569.000

2



Rivet



2 1/2 SP

Location

Loc Qty

Loc Code

ST317

1569

110139

769

117505

800

MS21073L5}

Purchased

No

105

Each

147.0000

1



nut plate



1 SP

Location

Loc Qty

Loc Code

ST302

100

117395

100

ST303

47

113660

27

116583

20

MS27039C1-27

Purchased

No

105

Each

47.0000

2



Screw



2 1/2 115/15 SP

Location

Loc Qty

Loc Code

ST293

47

115768

47

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

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Work Order ID: 69790

Parent Item: D407-802-018

Parent Item Name: Passenger Door Opener Installation, RH

Start Date: 5/19/2011

Required Date: 5/19/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

105

Each

3,002.000

2

2



Washer

Location

Loc Qty

Loc Code

ST297

3002

116304

55

117291

2347

117460

600

NAS1149C1165R

Purchased

No

105

Each

97.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST297

97

115768

97

NAS1149C0532R

Purchased

No

105

Each

348.0000

6

6



WASHER

Location

Loc Qty

Loc Code

ST297

348

116289

48

116373

100

116513

200

NAS1149C0563R

Purchased

No

105

Each

574.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST297

574

112532

100

115768

74

116391

200

117460

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

## REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D407-802-1

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### 5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017	Qty -018	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

### 5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

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Revision: **A**  
Date: 10.10.13

